



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3910-3

Job Sheet 180275



Part No: D3910-3

Job Qty: 20 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 8/22/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	20 pcs		8/22/18	0.00	0.00	Purchasing		AUG 20 2018
120	Packaging	20 pcs		8/22/18	0.00	0.00	Packaging2		AUG 20 2018
130	QC	20 pcs		8/22/18	0.00	0.00	QC6		18/08/22 AT
180	Packaging	20 pcs		8/22/18	0.00	0.00	Packaging3-2	5.523	
190	QC21-SA	20 Ea		8/22/18	0.00	0.00	QC21		AUG 31 2018

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
 Descriptions: 120 - Ensure C of C is attach

PO 040351 21 JUL 04 2018 AUG 31 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	2.5000 ft (.125 ea)	110-Purchasing	S103685
D3910-3P	Crosstube Lug	20 pcs (1 ea)	110-Purchasing	S103686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	53	BK 1804-23.
	D3910-3P	20	0	0



Container No: S103687

Part: D3910-3

Job No: 180275

Serial No/Batch: S103687

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/20/18

Plex 7/4/18 8:38 AM dart.lavoie.chantal

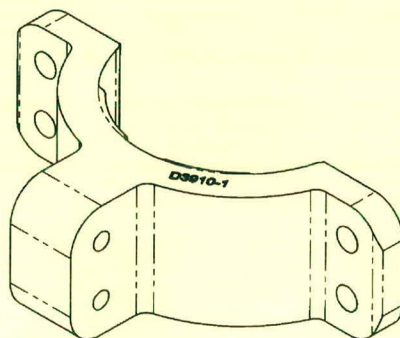
Hand Finish 1 D.R 18/08/22

Start: 11:15 am

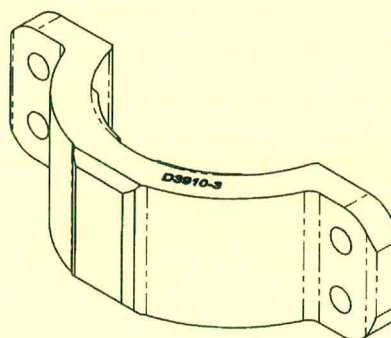
Finish: 11:50 am 0.58.

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches $\pm$ 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches $\pm$ 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches $\pm$ 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches $\pm$ 0.030	1.230 1.170	Radius	
8	Crosstube Lug	3.700Inches $\pm$ 0.010	3.710 3.690		
9	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
10	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
11	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
12	Crosstube Lug	0.340Inches $\pm$ 0.030	0.370 0.310	Radius	
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
14	Crosstube Lug	0.100Inches $\pm$ 0.010	0.110 0.090		
15	Crosstube Lug	45.000Degrees $\pm$ 0.500	45.500 44.500	angle	
16	Crosstube Lug	1.410Inches $\pm$ 0.030	1.440 1.380	Reference	

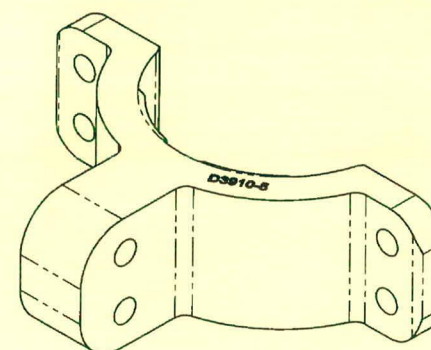
Plex 7/4/18 8:38 AM dart.lavoie.chantal



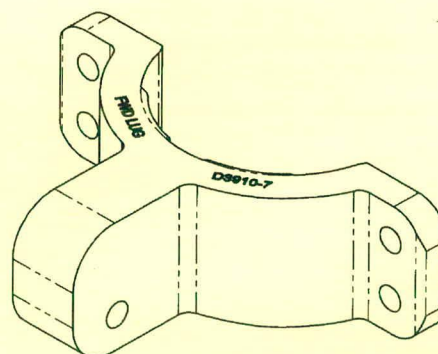
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005

RELEASED

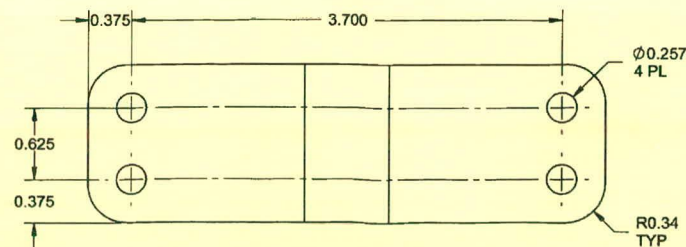
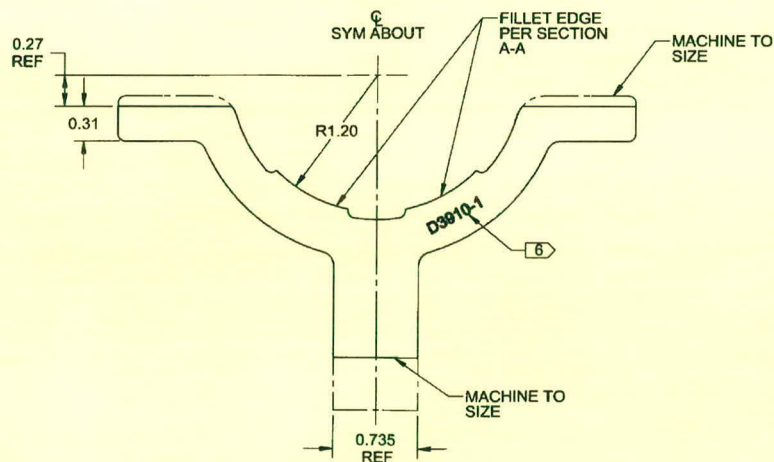
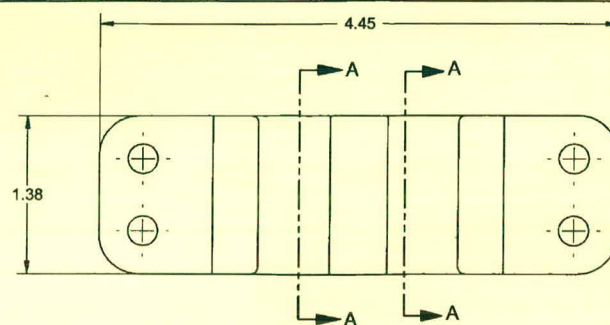
2014 JUN 05
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JPH	DRAWING NO.	REV. E
MFG. APPR.	JPH	D3910	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

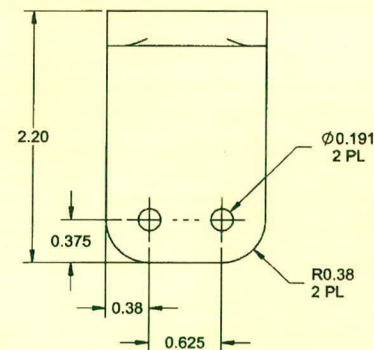


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG



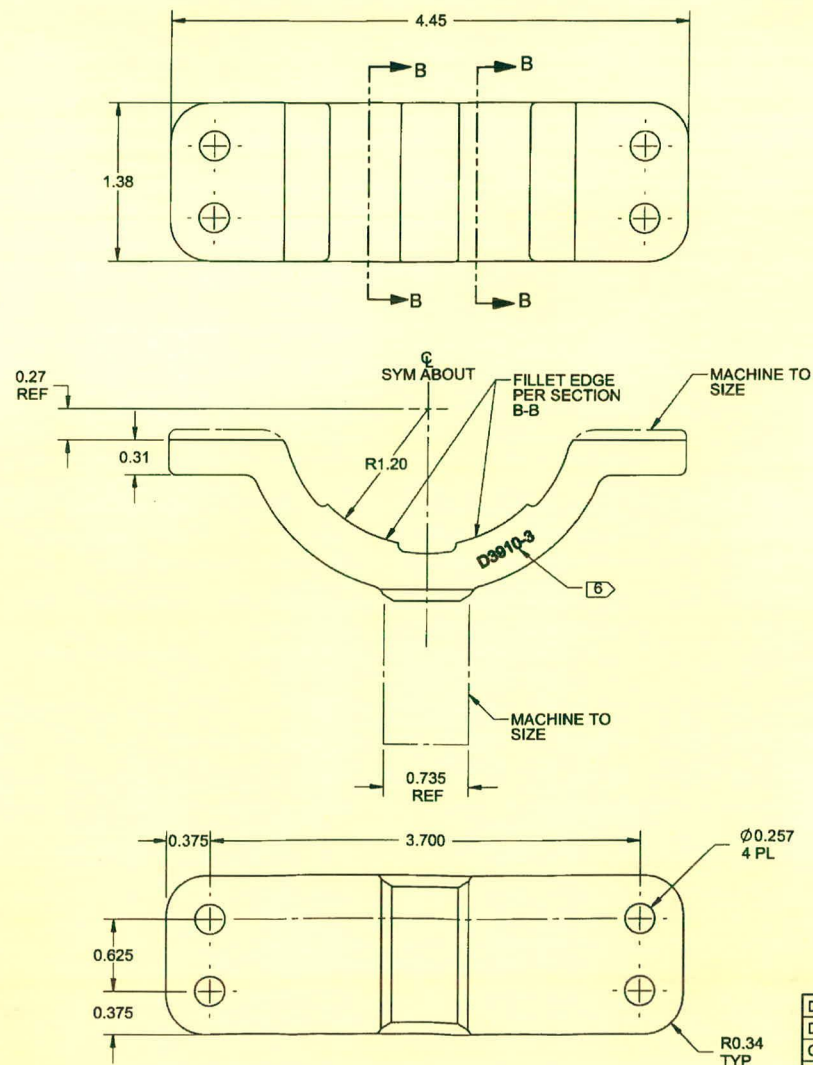
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3910	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

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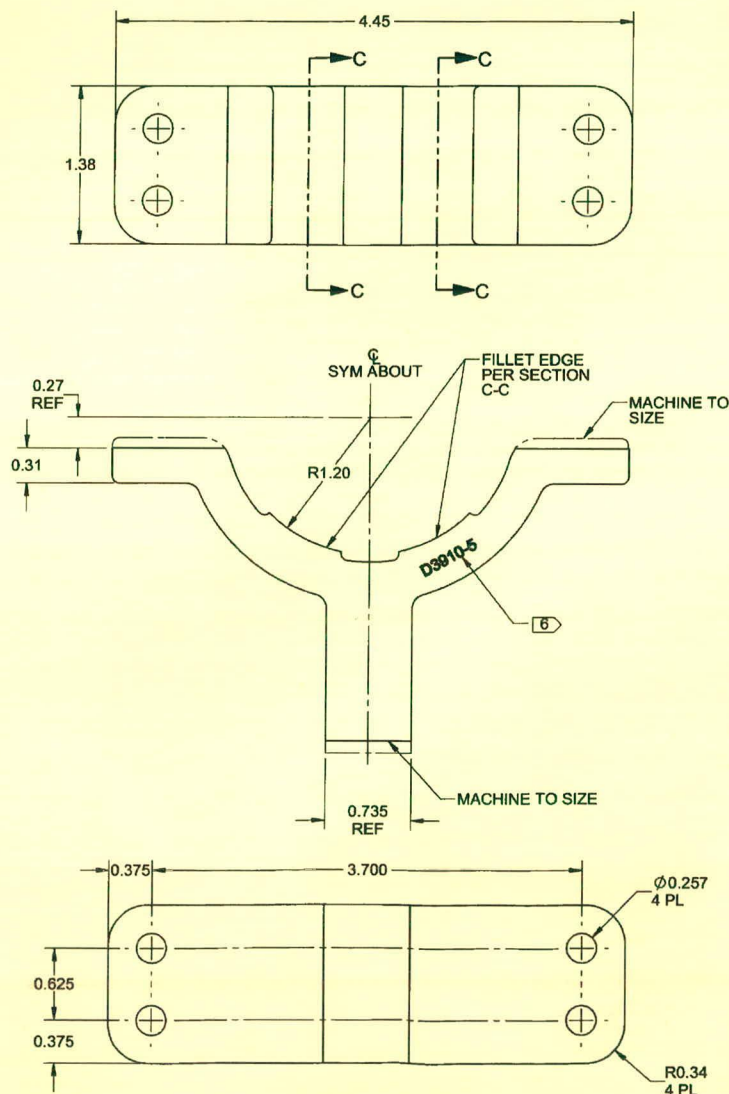
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	4/	D3910	SHEET 3 OF 5
APPROVED	4/	TITLE	SCALE
DE APPR.	4/	X-TUBE LUG (350)	NTS
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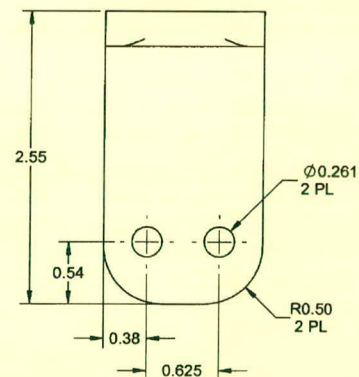
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



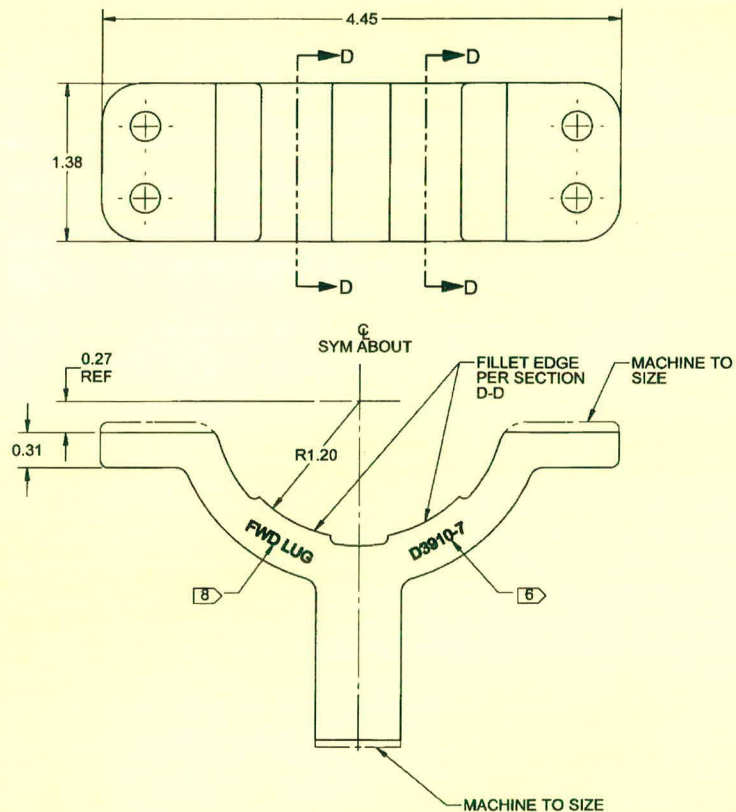
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2014 JUN 05

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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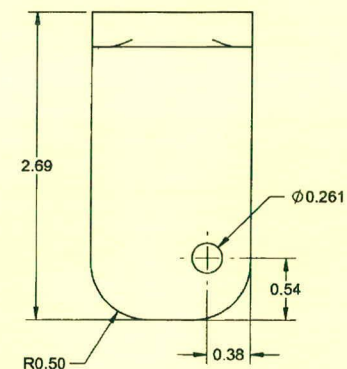
SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-7 X-TUBE LUG



RELEASED

2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3910	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040391**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

PO No: PO040391

PO Date: 7/4/18

Due Date: 8/20/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane Phone:
dbaker@dartaero.com

Attention: Walz, Shigi

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180263	D2230-1P	X24		Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI 005	Firmed	-	8/20/18	100 pcs	0 pcs	100 pcs	\$17.40/pcs	\$1,740.00
	182015	X38							62 X	AUG 15 2018			
	182016	X38											
2	180266	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	8/20/18	100 pcs	0 pcs	100 pcs	\$14.90/pcs	\$1,490.00
	182013								20 X	AUG 15 2018			
3	180269	D2731-3P			Lug As Per Dwg D2731 Rev.C	Firmed	-	8/20/18	30 pcs	0 pcs	30 pcs	\$16.20/pcs	\$486.00
									32 X	AUG 15 2018			
4	180272	D3394-1P			Lug As Per Dwg D3394 Rev. B	Firmed	-	8/20/18	30 pcs	0 pcs	30 pcs	\$20.45/pcs	\$613.50
									30 X	AUG 15 2018			
5	180273	D3910-1P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
									20 X	AUG 15 2018			
6	180275	D3910-3P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
									20 X	AUG 20 2018			
7	180277	D3910-7P			Crosstube Lug As Per Dwg. D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
									20 X	AUG 15 2018			

DAS
61
9-89

Items												
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD) Extended Price
Grand Total:												\$5,373.50
Order Notes												
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation. Procurement Quality Clauses A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM A049 SUPPLIER AWARENESS												

Plex 7/10/18 9:11 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.**

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22864

Date: Aug 20, 2018

Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040391 NC	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Aug 20, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D2230-1 Mounting Lug ✓ 62 stock Not painted		Each	100	38 ✓	
D2230-3 Mounting Lug no stock Not painted		Each	100	80	
D2731-3 Mounting Lug in stock alodined and painted as per QSI 005		Each	30		
D3394-1 Lug in stock alodined and painted as per QSI 005		Each	30		
D3910-1 Crosstube Lug in stock alodined and painted as per QSI 005		Each	20		
D3910-3 Crosstube Lug ✓ no stock Not painted		Each	20	20 ✓	
D3910-7 Crosstube Lug in stock alodined and painted as per QSI 005		Each	20		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		

DAS
61
9-8



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
38	D2230-1	Mounting Lug	101186	Unpainted	40391
DAS 80	D2230-3	Mounting Lug	160522	Unpainted	40391
61 20 9-89	D3910-3	Crosstube Lug	160522	Unpainted P.D.	40391

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, August 20, 2018

